

Work Order ID 71446

Monday, July 04, 2011 1:04:59 PM



Page 1

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	7/5/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	7/19/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>AME</u>	Date:	<u>11-07-04</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	<p>1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989</p> <p>2- tack weld mesh on basket as per dwg D2989 using DT9445 jig</p> <p>****cut cutouts with zip cut as per dwg D3832****</p> <p>3- remove from jig and weld lable plate as per dwg D2989</p> <p>A/R ER316 S.S. Rod Batch: <u>117384</u></p> <p>*** PLEASE NOTE****</p> <p>IF MAKING -043A :</p> <p>ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER DS19473</p>								

11.07.08

110	QC9- Inspet visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

11.07.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71446

Monday, July 04, 2011 1:05:00 PM



Page 2

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid Assembly				Stop	
Start Date:	7/5/2011	Start Qty:	1.00			
Required Date:	7/19/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
125 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

Handwritten signature and date: 11/07/08

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Monday, July 04, 2011 1:05:00 PM



Page 4

Item ID: D2989-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1.00 3/11/07/11

141

Identify as per dwg & Stock Location: *B.A.*

0.00



Packaging

Memo

0.00

Packaging

Wb
71445

SPC 11/07/11

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11
me
11-07-11

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Picklist Print

Monday, July 04, 2011 1:04:57 PM

Page 1

Work Order ID: 71446

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/5/2011


Required Date: 7/19/2011

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1  Rib		Manufactured	No			100	Each	8.0000	2	2		07-11-07	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	5	
69261	5	
WA006	3	
67465	3	

D2506  Label Plate		Manufactured	No			100	Each	2.0000	1	1		07-11-07	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	2	
69262	2	

D2512-7  Rib		Manufactured	No			100	Each	8.0000	1	1		07-11-7-7	
--	--	--------------	----	--	--	-----	------	--------	---	---	--	-----------	--

Location	Loc Qty	Loc Code
WA	4	
53444	0	
71220	4	
WA006	4	
67445	4	

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Page 2

Work Order ID: 71446

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

87.0000

2

2



Mounting Bracket



Pl 11.07.07

Location

Loc Qty

Loc Code

WA

87

69258

28

69739

8

70766

51

2

D2989-13

Manufactured No

100

Each

4.0000

2

2



Rib



Pl 11.07.07

Location

Loc Qty

Loc Code

WA005

4

69128

4

100

Each

4.0000

2

2

D2989-19

Manufactured No



Rib



Pl 11.07.07

Location

Loc Qty

Loc Code

WA

4

70134

4

100

Each

4.0000

1

1

D3832-3

Manufactured No



Mesh (Lid)



Pl 11.07.07

Location

Loc Qty

Loc Code

WA

4

67501

1

69276

3

1

Monday, July 04, 2011 1:04:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 71446

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3

Manufactured No

100

Each

25.0000

2

2



Mesh (Lid End)



Pl 11.07.07

Location

Loc Qty

Loc Code

WA

25

67460

25

2

D3836-041

Manufactured No

100

Each

0.0000

1

1



Rib Assembly (Basket Lid, LH)



B70681 -> 1 Pl 11.27.07

D3836-042

Manufactured No

100

Each

0.0000

1

1



Rib Assembly (Basket Lid, RH)



B70679 -> 1 Pl 11.07.07

D3852-041

Manufactured No

100

Each

0.0000

1

1



Rib Assembly



B70722 -> 1 Pl 11.02.07

D3852-042

Manufactured No

100

Each

1.0000

1

1



Rib Assembly



B70723 -> 1 Pl 11.07.07

Location

Loc Qty

Loc Code

WA

1

66089

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

#71446

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG); REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	06.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

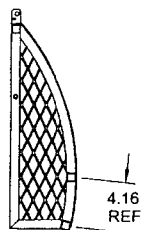
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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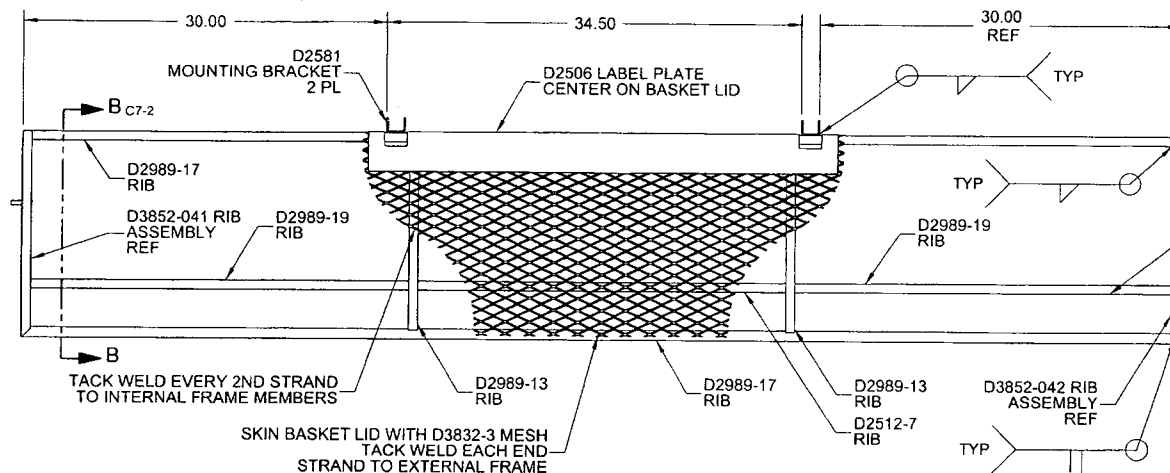
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

SECTION B-B



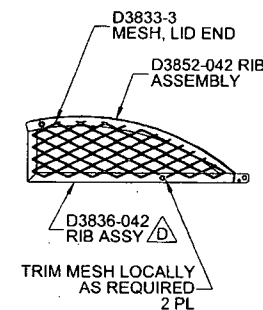
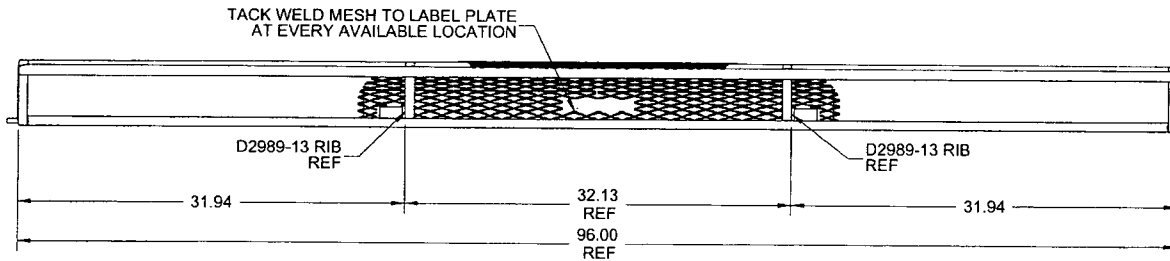
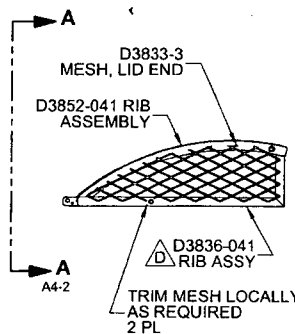
D7-2



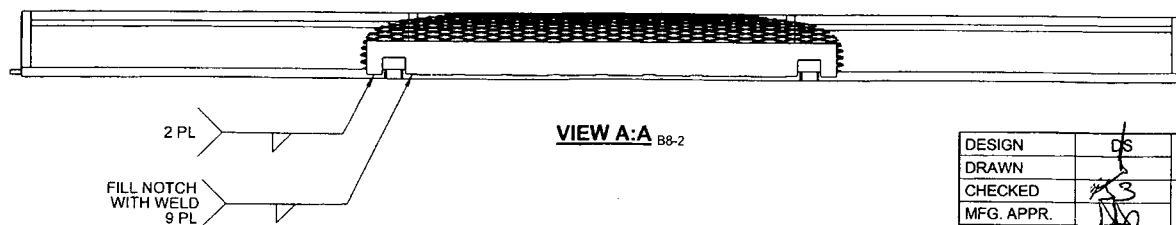
TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID
PAINT THIS SECTION

#71446



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



VIEW A-A B8-2

RELEASED
08/11/18/19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE BASKET LID ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

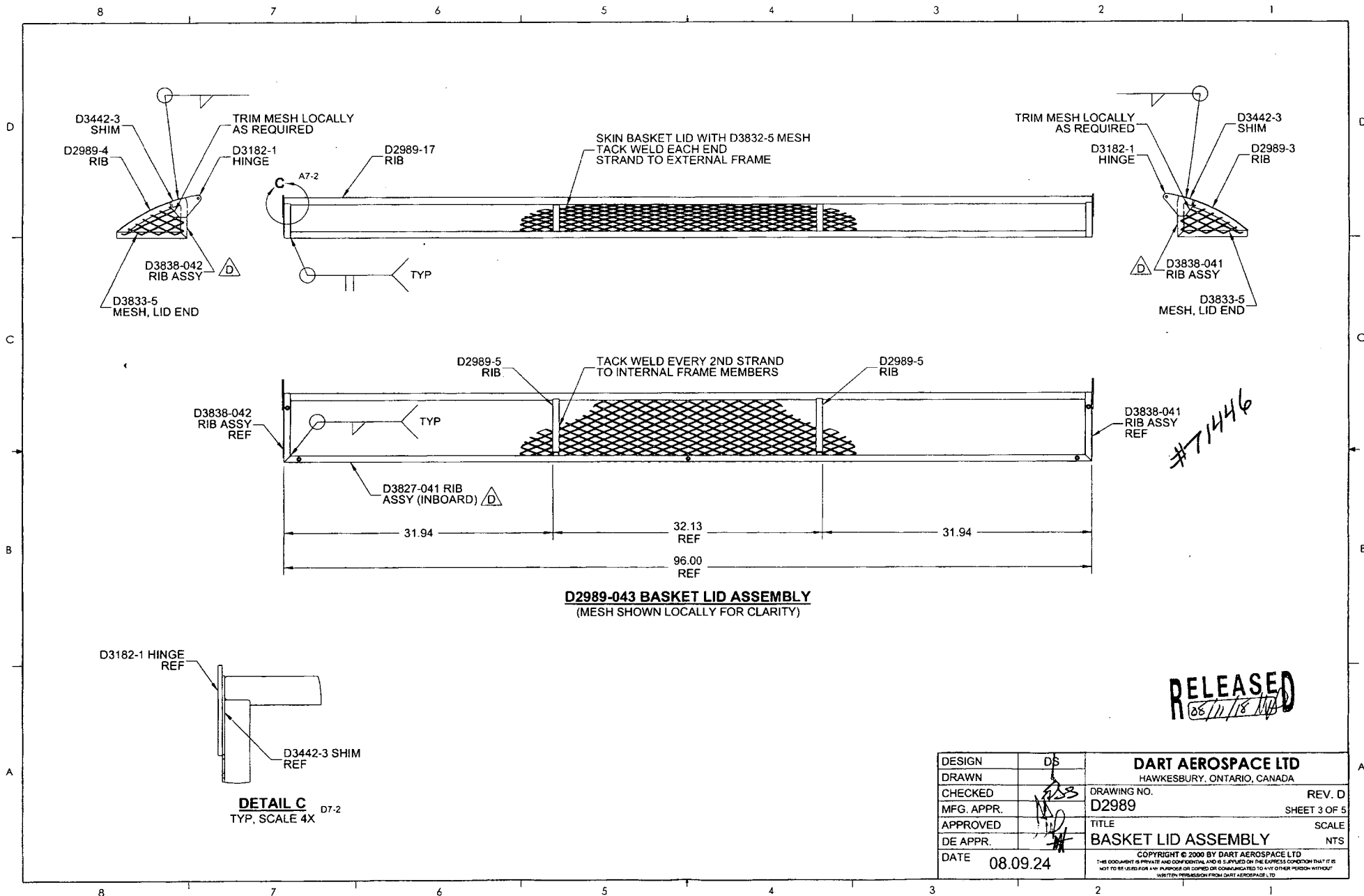
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CHECKED	<i>DS</i>	DRAWING NO.	REV. I
MFG. APPR.		D2989	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY	NTS
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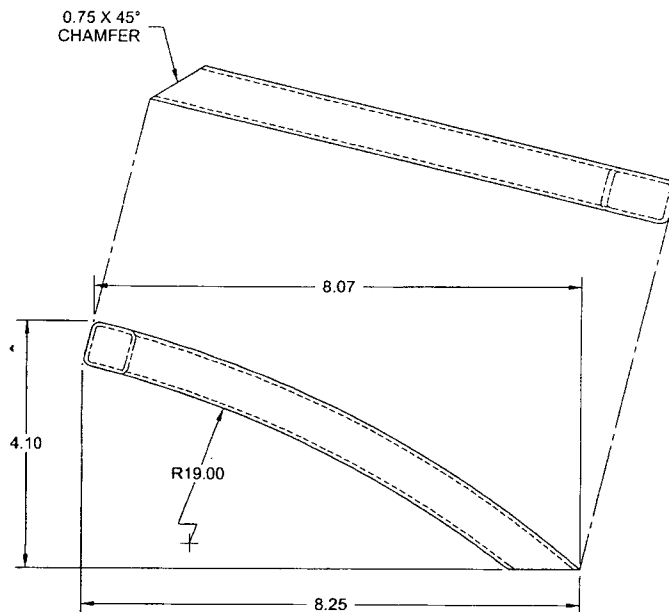
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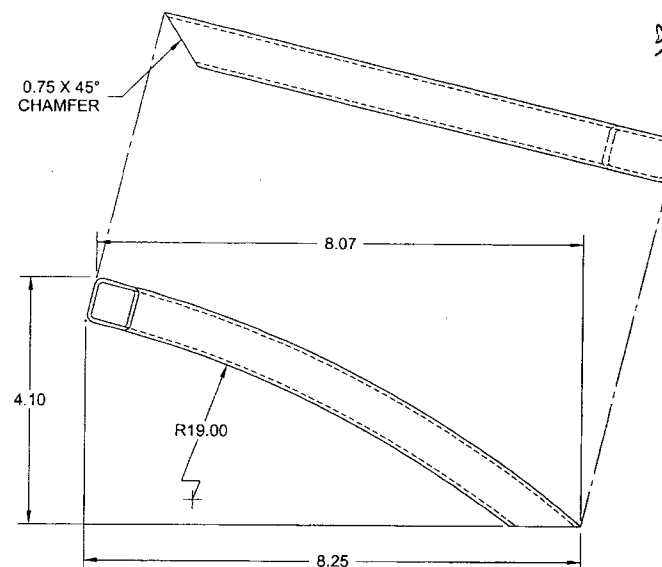
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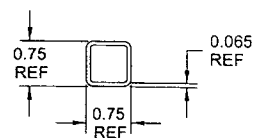
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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08/11/18

#714416

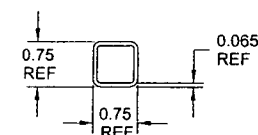
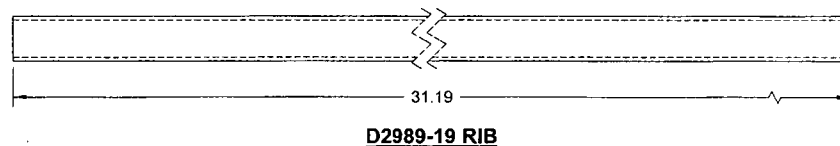
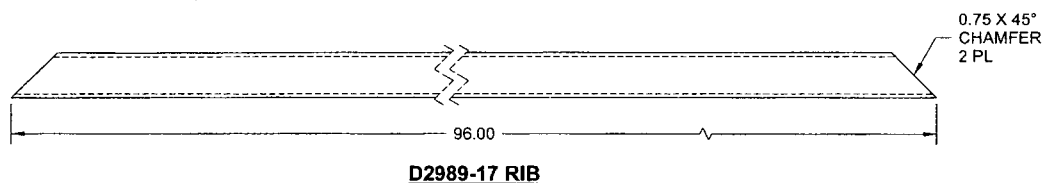
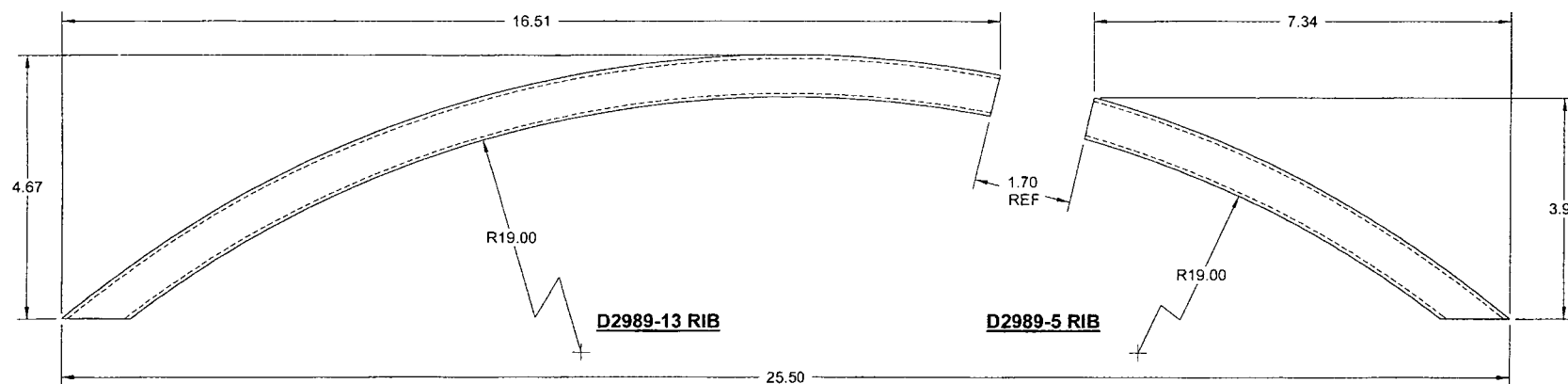
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TYPICAL SECTION
VIEW

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries